



CEWELD S1

TYPE Solid wire for welding non-alloyed steel

APPLICATIONS Shipbuilding, pressure vessels, steel structures.

PROPERTIES Coppered solid wire for SAW welding in combination with our FL 180 flux

CLASSIFICATION

AWS	A 5.23: EL12, A 5.17: EL12
EN ISO	14171-A: S1
F-nr	6
FM	1

SUITABLE FOR Unalloyed steels: St 33 – St 52 Ship building: A, E, AH, EH Boiler steels: H1-H111, 17Mn4, Pipe steels: St 37.0/4 – St 52.0/4 Fine-grain steels: StE 255 – StE 420

APPROVALS CE

WELDING POSITIONS



TYPICAL CHEMICAL ANALYSIS OF THE FILLER METAL (%)	C	Si	Mn	P	S
	0.1	0.5	0.5	0.015	0.02

MECHANICAL PROPERTIES	Heat Treatment	R _{p0,2} (MPa)	R _m (MPa)	A ₅ (%)	Impact Energy (J) ISO-V	Hardness
					0°C	
	As Welded	410	530	26	60	HRc

REDRYING Not required

GAS ACC. EN ISO 14175



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S1 2,4MM

Packaging	KG/unit	EanCode
K-415	25	8720663404251

S1 3,2MM

Packaging	KG/unit	EanCode
K-415	25	8720663404268